



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D350-591-113
Job Sheet 195407



Part No: D350-591-113

Job Qty: 10 pcs

Part Name: Hell-Access Step, Short, High Gear



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/22/19

Job Tracking No:

Created By: Jennifer Renwick

Due Date: 8/20/19

Description: Order 16536

Type: **SOLD**

Note: DWG DSI 9525 REV A, D2310 REV D IPP Rev:H 04.11.09 Reformat KJ/JLM IPP Rev:E as per EGN10-586
10.06.18 DD ver:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Large Fab - Steps - 1	10 pcs	8/20/19		0.00	20.00	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
115	QC 5	10 pcs	8/20/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							Conventional Mill - 1 - B4B		
							Conventional Mill - 2 - B4B		



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CANADA
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Container No: S206202



Part: D350-591-113

Job No: 195407

Serial No/Batch: S206202

Revision:

Inspector:

Exp Date:

Instructions:

Date: 08/21/19

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[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

https://www.plexonline.com/3d6d259a-27ce-4980-8d64-2e8d8ae0af1a/Plexus_Control/Report_Viewer_2.asp?URL=../Part/Job_Sheet.asp&Report=Tru... 2/7

				Large Fab - 2 - B4B	
				Large Fab - 3 - B4B	
				Large Fab - 4 - B4B	DAS
				Large Fab - 5 - B4B	24
				Large Fab - 6 - B4B	9-89
				Large Fab - 7 - B4B	
				Large Fab - 8 - B4B	
				Large Fab - 9 - B4B	
140	QC 5	10 pcs	8/20/19	0.00 0.00	QC 5 - 10
					QC 5 - 12
					QC 5 - 17
					QC 5 - 18
					QC 5 - 19
					QC 5 - 22
					QC 5 - 24
					QC 5 - 3
					QC 5 - 43
					QC 5 - 49
					QC 5 - 51
					QC 5 - 58
					QC 5 - 68
					QC 5 - 9
					QC 5 - 50
					QC 5 - 30
					QC 5 - 40
150	QC 9	10 pcs	8/20/19	0.00 0.00	QC 9 - 10
					QC 9 - 18
					QC 9 - 24
					QC 9 - 43
					QC 9 - 50
					QC 9 - 9
165	Handfinish - 1-1 Chemical-B4B	10 pcs	8/20/19	0.00 2.22	Handfinish - 1 - 1 - B4B
					Handfinish - 1 - 2 - B4B
					Handfinish - 1 - 3 - B4B
					Handfinish - 1 - 4 - B4B
					Handfinish - 1 - 5 - B4B
					Handfinish - 1 - 6 - B4B
					Handfinish - 1 - 7 - B4B
					Handfinish - 1 - 8 - B4B
					Handfinish - 1 - 9 - B4B
					Handfinish - 1 - 10 - B4B
					Handfinish - 1 - 11 - B4B
					Handfinish - 1 - 12 - B4B
					Handfinish - 1 - 13 - B4B
					Handfinish - 1 - 14 - B4B
					Handfinish - 1 - 15 - B4B
					Handfinish - 1 - 16 - B4B
					Handfinish - 1 - 17 - B4B
					Handfinish - 1 - 18 - B4B
					Handfinish - 1 - 19 - B4B
					Handfinish - 1 - 20 -

				B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
170 Large Fab - Steps - 2 - B4B	10 pcs	8/20/19	0.00 10.32	Large Fab - 1 - B4B	
				Large Fab - 10 - B4B	SL
				Large Fab - 2 - B4B	
				Large Fab - 3 - B4B	
				Large Fab - 4 - B4B	
				Large Fab - 5 - B4B	
				Large Fab - 6 - B4B	
				Large Fab - 7 - B4B	
				Large Fab - 8 - B4B	
				Large Fab - 9 - B4B	
180 QC 10	10 pcs	8/20/19	0.00 0.00	QC 10 - 10	
				QC 10 - 18	
				QC 10 - 24	
				QC 10 - 43	
				QC 10 - 50	AUG 23 2019 DAS 50
				QC 10 - 58	
				QC 10 - 9	
190 QC 5	10 pcs	8/20/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	AUG 23 2019 DAS 68
				QC 5 - 9	9-89
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
200 Handfinish - 1-2- Chemical-B4B	10 pcs	8/20/19	0.00 2.22	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	OR AUG 23 2019
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	

						Handfinish - 1 - 16 - B4B	
						Handfinish - 1 - 17 - B4B	
						Handfinish - 1 - 18 - B4B	
						Handfinish - 1 - 19 - B4B	
						Handfinish - 1 - 20 - B4B	
						Handfinish - 1 - 21 - B4B	
						Handfinish - 1 - 22 - B4B	
210 Powdercoat - 1 White Gl(A)- B4B	10 pcs	8/20/19	0.00	2.06		Powdercoat - 1 - B4B	
						Powdercoat - 2 - B4B	
						Powdercoat - 3 - B4B	
						Powdercoat - 4 - B4B	
220 Handfinish - 3-1- WingWalk- B4B	10 pcs	8/20/19	0.00	2.22		Handfinish - 3 - 1 - B4B	
						Handfinish - 3 - 2 - B4B	
						Handfinish - 3 - 3 - B4B	
						Handfinish - 3 - 4 - B4B	
						Handfinish - 3 - 5 - B4B	
230 QC 3	10 pcs	8/20/19	0.00	0.00		QC 3 - 10	
						QC 3 - 13	
						QC 3 - 15	
						QC 3 - 17	
						QC 3 - 18	
						QC 3 - 2	
						QC 3 - 28	
						QC 3 - 3	
						QC 3 - 30	
						QC 3 - 34	
						QC 3 - 36	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	
						QC 3 - 68	
						QC 3 - 9	
						QC 3 - 40	
						QC 3 - 19	
						QC 3 - 43	
						QC 3 - 24	
240 Packaging 1-1 - Pick Kit - B4B	10 pcs	8/20/19	0.00	0.00		Packaging 1 - 1 - B4B	
						Packaging 1 - 2 - B4B	
						Packaging 1 - 3 - B4B	
						Packaging 1 - 4 - B4B	
						Packaging 1 - 5 - B4B	
						Packaging 1 - 6 - B4B	
						Packaging 1 - 7 - B4B	
						Packaging 1 - 8 - B4B	
						Packaging 1 - 9 - B4B	
						Packaging 1 - 10 - B4B	
						Packaging 1 - 11 - B4B	
						Packaging 1 - 12 - B4B	
						Packaging 1 - 13 - B4B	
						Packaging 1 - 14 - B4B	
						Packaging 1 - 15 - B4B	
						Packaging 1 - 16 - B4B	

				Packaging 1 - 17 - B4B	
				Packaging 1 - 18 - B4B	
				Packaging 1 - 19 - B4B	
				Packaging 1 - 20 - B4B	
				Packaging 1 - 21 - B4B	
				Packaging 1 - 22 - B4B	
				Packaging 1 - 23 - B4B	
				Packaging 1 - 24 - B4B	
				Packaging 1 - 25 - B4B	
				Packaging 1 - 26 - B4B	
				Packaging 1 - 27 - B4B	
				Packaging 1 - 28 - B4B	
				Packaging 1 - 29 - B4B	
				Packaging 1 - 30 - B4B	
				Packaging 1 - 31 - B4B	
				Packaging 1 - 32 - B4B	
				Packaging 1 - 33 - B4B	
				Packaging 1 - 34 - B4B	
				Packaging 1 - 35 - B4B	
				Packaging 1 - 36	
250 QC 4	10 pcs	8/20/19	0.00 0.00	QC 4 - 28	
				QC 4 - 58	
				QC 4 - 69	
				QC 4 - 9	
				QC 4 - 46	
				QC 4 - 68	
				QC 4 - 72	
				QC 4 - 74	
260 Packaging 3-1 - Stock - B4B	10 pcs	8/20/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	

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				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
265 DC - 1 - B4B	10 pcs	8/20/19	0.00 0.00	DC - 1 - B4B	
				DC - 2 - B4B	
270 QC 21 - FG	10 pcs	8/20/19	0.00 0.00	QC 21 - FG - 21	
				QC 21 - FG - 70	
				QC 21 - SA - 53	

Part Op 110 - (Fabricate per Drwg) 1- Cut D2244 extrusion to 62.00" long as per Dwg D2310 2- Drill extrusion as per Dwg D2310
 Descriptions: using drill Jlg DT8230

- 115 -
 120 - 1- OPEN HOLE FOR BUSHING TO SIZE AS PER DWG AND C'SINK.
 135 - 1- Weld Fwd end cap and bushing as per Dwg D2310 A/R AL ROD Batch: 2- Grind end cap and bottom bushing welds flush 3- Machine top weld on bushing flush as per dwg.
 140 - (QC5- Inspect part completeness to step on W/O)
 165 - (Chemical Conversion Coat per QSI005 4.1)
 170 - (Weld per dwg A/R Aluminum rod Batch:) 1-Rivet as per Dwg D2310 3-Weld Aft end cap as per Dwg D2310 A/R AL ROD Batch: 4-Grind end cap welds flush
 180 - (QC10- Inspect visual per QSI004- ground welds)
 190 - (QC5- Inspect part completeness to step on W/O)
 200 - (Chemical Conversion Coat per QSI005 4.1)
 210 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: FINISH TIME:
 220 - (Wing Walk as per dwg QSI005 4.4 Batch) ***Install Dart labels after wing walk***
 230 - (QC3- Inspect Part Finish) ***Install Dart labels after wing walk***
 240 - (Pick Kit)
 250 - (QC4- 100% Inspect kits for completeness)
 260 - (Identify as per dwg & Stock Location:) Identify and pack for shipping as per PPP D350-591-113
 265 - (Document Control) Photocopy bluefile & type labels per PPP D350-591-113 CHG005
 270 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2244-116	Step Extrusion	10 pcs (1 ea)	110-Large Fab - Steps - 1	
D2275	Bushing	10 pcs (1 ea)	135-Large Fab - Welded Assy-2- B4B	
D2673-34	End Plate	10 pcs (1 ea)	135-Large Fab - Welded Assy-2- B4B	
D2582	Hi-Skid Step Leg Assembly	10 pcs (1 ea)	170-Large Fab - Steps - 2 - B4B	
D2673-34	End Plate	10 pcs (1 ea)	170-Large Fab - Steps - 2 - B4B	
MS20600-AD4W3	Cherry Rivet	160 Ea (16 ea)	170-Large Fab - Steps - 2 - B4B	
K591-113	Short Step Installation	10 pcs (1 ea)	240-Packaging 1-1 - Pick Kit - B4B	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Large Fab - Steps - 1	D2244-116	10	20	0
135-Large Fab - Welded Assy-2- B4B	D2275	10	4	0
	D2673-34	10	9	0
170-Large Fab - Steps - 2 - B4B	D2582	10	3	0
	D2673-34	10	9	0
	MS20600-AD4W3	160	356	0
240-Packaging 1-1 - Pick Kit - B4B	K591-113	10	2	0

Part Specifications

Specifications could not be found.

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only



Job: _____ Part No. _____		DISPOSITION Rework ☐ ☐ ☐ Scrap ☐ ☐ ☐ Use-as-is ☐ ☐ ☐				DEPARTMENT/PROCESS Skid-tube ☐ ☐ ☐ ☐ ☐ Machining ☐ ☐ ☐ ☐ ☐ Large Fab ☐ ☐ ☐ ☐ ☐				Cross tube ☐ ☐ ☐ ☐ ☐ Small Fab ☐ ☐ ☐ ☐ ☐ Finishing ☐ ☐ ☐ ☐ ☐				Eng. (Non-AW) ☐ ☐ ☐ ☐ ☐ Prod. Eng. Coord. ☐ ☐ ☐ ☐ ☐ Rec/Store/Packaging ☐ ☐ ☐ ☐ ☐				Engineering ☐ ☐ ☐ ☐ ☐ Water Jet ☐ ☐ ☐ ☐ ☐ Supplier ☐ ☐ ☐ ☐ ☐ Quality ☐ ☐ ☐ ☐ ☐																																																																	
Date : _____		Sequence #: _____		QTY Affected : _____		MRB (QS1042)																																																																													
Description Work Order Deviation						Disposition																																																																													
Root Cause <table border="1"> <tr> <td>Operator</td><td>☐</td> </tr> <tr> <td>Manufacturing Process</td><td>☐</td> </tr> <tr> <td>Equip/Tooling</td><td>☐</td> </tr> <tr> <td>Handling/Preservation</td><td>☐</td> </tr> <tr> <td>Material</td><td>☐</td> </tr> <tr> <td>Product Improvement</td><td>☐</td> </tr> <tr> <td>Process Improvement</td><td>☐</td> </tr> <tr> <td>Human Factors</td><td>☐</td> </tr> </table>						Operator	☐	Manufacturing Process	☐	Equip/Tooling	☐	Handling/Preservation	☐	Material	☐	Product Improvement	☐	Process Improvement	☐	Human Factors	☐	FAULT CATEGORY <table border="1"> <tr> <td>Pressure/Forced</td><td>☐</td> <td>Contamination</td><td>☐</td> <td>Power Loss/Surge</td><td>☐</td> <td>Positioned Wrong</td><td>☐</td> </tr> <tr> <td>Bending</td><td>☐</td> <td>Misaligned/off center</td><td>☐</td> <td>Folio/Program</td><td>☐</td> <td>Outside Tolerance</td><td>☐</td> </tr> <tr> <td>Crushing</td><td>☐</td> <td>BOM/Route</td><td>☐</td> <td>Grain Direction</td><td>☐</td> <td>Drawing</td><td>☐</td> </tr> <tr> <td>Cracks</td><td>☐</td> <td>Broken/Damage/Defect</td><td>☐</td> <td>Weld</td><td>☐</td> <td>Finish</td><td>☐</td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave/Twist</td><td>☐</td> <td>Incomplete/Unclear Instructions</td><td>☐</td> <td>Wrong Stock Pulled</td><td>☐</td> <td>Part Lost/Missing</td><td>☐</td> </tr> <tr> <td>Marks/Chatter</td><td>☐</td> <td>Drill Holes</td><td>☐</td> <td>Out of Sequence</td><td>☐</td> <td>Misread</td><td>☐</td> </tr> <tr> <td>Mislabeled</td><td>☐</td> <td>Fit/Function</td><td>☐</td> <td>Off-set/Set-up</td><td>☐</td> <td></td><td></td> </tr> </table>						Pressure/Forced	☐	Contamination	☐	Power Loss/Surge	☐	Positioned Wrong	☐	Bending	☐	Misaligned/off center	☐	Folio/Program	☐	Outside Tolerance	☐	Crushing	☐	BOM/Route	☐	Grain Direction	☐	Drawing	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Finish	☐	Crimp/Kink/Ripple/Wave/Twist	☐	Incomplete/Unclear Instructions	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐	Marks/Chatter	☐	Drill Holes	☐	Out of Sequence	☐	Misread	☐	Mislabeled	☐	Fit/Function	☐	Off-set/Set-up	☐		
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Human Factors	☐																																																																																		
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Other/Details: _____																																																																																			
Completed By						Lead hand / Supervisor																																																																													
QC / QA Coordinator																																																																																			

Change Record

Part Number: D350-591-113 (K591-113 PRODUCTION KIT)

PAGE 1 OF 1

Description: HELI-ACCESS STEP, HIGH SKID, SHORT STEP

[illegible]